

Work Order ID 85087

85087

Page 1

Friday, June 01, 2012 3:27:00 PM

Item ID: PB67-43001-01

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 12-06-20 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-01

Rev C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg and notes on dwg B67-43001 and use 242 threadlock Blue
A/R shown on dwg PB67-43001 page 2.
242 THREADLOCK Blue batch:
A/R touch up paint with sandflex green
batch: *m112961*

1 0
12.06.27
12.06.27

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8/12/06/29

(XL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85087

Friday, June 01, 2012 3:27:00 PM

85087

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Item ID: PB67-43001-01

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

OK 12/7/10.
MF
12-07-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec
EC verified by:DD
IPP RevC 10.09.24 per RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 SPRING SLOTTED PIN		Purchased	No			100	Each	82.0000	8	8		12/20/89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST400		82							
				115827		82							
30345T22 8" LANYARD		Purchased	No			100	Each	18.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		18							
				112853		18							
30345T24 LANYARDS		Purchased	No			100	Each	42.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST401		42							
				112853		42							
AN4-10A Bolt		Purchased	No			100	Each	81.0000	2	2		12/6/25	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		81							
				117619		31							
				121666		50							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No

100 Each 1,261.0000 2 2

Bolt

Location

Loc Qty

Loc Code

ST357

1261

119449

33

120187

19

120422

2

120770

207

121652

1000

AN4-15A Purchased No

100 Each 527.0000 4 4

Bolt

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

327

118706

3

120422

24

121444

100

121541

200

AN6-11A Purchased No

100 Each 71.0000 1 2

BOLT

Location

Loc Qty

Loc Code

ST341

71

111177

21

114437

50

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

AN6-20A Purchased No

100 Each 51.0000

2 2

Bolt

Location

Loc Qty

Loc Code

ST341

50

118706

50

ST342

1

114941

1

118706

0

AN8-13A

Purchased

No

100 Each 14.0000

2 2

BOLT

Location

Loc Qty

Loc Code

ST343

14

110915

14

BSP43

Purchased

No

100 Each 55.0000

4 4

RIVET

Location

Loc Qty

Loc Code

ST284

55

110704

50

111127

5

CR3213-4-05

Purchased

No

100 Each 141.0000

2 2

cherry rivet

Location

Loc Qty

Loc Code

ST331

141

108473

41

108991

100

D3445-041

Manufactured

No

100 Each 4.0000

1

Belt Assembly

Location

Loc Qty

Loc Code

ST440

4

52615

4

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

D3447-3 Manufactured No 100 Each 5.0000

Square Spacer

Location Loc Qty Loc Code

ST440 5

41351 1

58012 4

D3447-7 Manufactured No 100 Each 6.0000

Clevis

Location Loc Qty Loc Code

ST440 6

52665 6

D3447-9 Manufactured No 100 Each 8.0000

Swing Arm

Location Loc Qty Loc Code

ST440 8

57745 4

62127 4

D3451-041 Manufactured No 100 Each 1.0000

Handle and Lock-Down Assembly

Location Loc Qty Loc Code

ST440 1

52565 1

D3451-047 Manufactured No 100 Each 1.0000

Handle and Lock-Down Assembly

Location Loc Qty Loc Code

ST442 1

52568 1

D3922-1 Manufactured No 100 Each 42.0000

Clip

Location Loc Qty Loc Code

ST070 42

66852 42

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS17984-C408
PIN, QUICK RELEASE

Purchased

No

100 Each 8.0000

2

2

Location

Loc Qty

Loc Code

ST314

8

112940

8

MS17984-C418
PIN, QUICK RELEASE

Purchased

No

100 Each 20.0000

2

Location

Loc Qty

Loc Code

ST315

20

114416

3

114523

17

MS21042L3
Nut

Purchased

No

100 Each 2,195.0000

2

Location

Loc Qty

Loc Code

ST300

2195

117885

32

119017

952

119075

138

121349

221

121444

852

MS21042L4
Nut

Purchased

No

100 Each 3,910.0000

8

8

Location

Loc Qty

Loc Code

ST300

3910

119075

116

121011

537

121444

2957

121652

300

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L6 Purchased No 100 Each 648.0000

4 4

Nut

Location	Loc Qty	Loc Code
ST300	648	
117677	25	
118384	3	
118927	48	
119075	372	
120308	200	

MS27039-1-04 Purchased No 100 Each 411.0000

2

SCREW

Location	Loc Qty	Loc Code
ST291	411	
119638	3	
120142	100	
120308	34	
120910	74	
121476	200	

MS27039-1-21 Purchased No 100 Each 200.0000

2

SCREW

Location	Loc Qty	Loc Code
ST291	100	
115935	100	
ST292	100	
115935	100	

MS51859-6 Purchased No 100 Each 108.0000

4

WASHER

Location	Loc Qty	Loc Code
ST296	108	
111279	8	
112940	100	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 7

Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

MS51859-7 Purchased No Each 22.0000

Washer

Location	Loc Qty	Loc Code
ST296	22	
111193	12	
120518	10	

MS51859-8 Purchased No 100 Each 46.0000

WASHER

Location	Loc Qty	Loc Code
ST296	46	
112940	46	

NAS1149DN632J Purchased No 100 Each 200.0000

Washer

Location	Loc Qty	Loc Code
ST298	200	
118428	200	

NAS1149F0316P Purchased No 100 Each 245.0000

WASHER

Location	Loc Qty	Loc Code
ST275	245	
112940	45	
113237	100	
113644	100	

NAS1149F0432P Purchased No 100 Each 792.0000

Washer

Location	Loc Qty	Loc Code
ST275	792	
121350	792	

NAS1149F0632P Purchased No 100 Each 465.0000

WASHER

Location	Loc Qty	Loc Code
ST275	465	
18057	465	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0832P Purchased No 100 Each 248.0000

WASHER

Location Loc Qty Loc Code

ST275 248

18057 248

NAS43DD3-68 Purchased No 100 Each 36.0000

SPACER

Location Loc Qty Loc Code

ST278 1

112410 1

ST279 35

120142 35

~~PB67-43001-01~~
PB67-43001-07 Manufactured No 100 Each 0.0000

Fwd Blade Fold Assembly Weldment

PB67-43001-11 Manufactured No 100 Each 0.0000

Fwf Adjustable Blade Support Assembly

PB67-43001-15 Manufactured No 100 Each 0.0000

Fwf Adjustable Blade Support Assembly

PB67-43001-21 Manufactured No 100 Each 0.0000

PB67-43001-21

PB67-43001-23 Manufactured No 100 Each 0.0000

PB67-43001-23

PB67-43001-261 Manufactured No 100 Each 12.0000

Lever Arm

Location Loc Qty Loc Code

ST432 12

62182 12

PB67-43001-265 Manufactured No 100 Each 11.0000

Deltin Bushing

Location Loc Qty Loc Code

ST438 11

40056 11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 85087

Parent Item: PB67-43001-01

Parent Item Name: Fwd Blade Fold Assembly

Start Date: 6/1/2012

Required Date: 6/29/2012

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-299

Manufactured

No

100

Each

17.0000

2

Bushing

Location

Loc Qty

Loc Code

ST439A

17

44969

17

PB67-43001-45

Manufactured

No

100

Each

0.0000

1

Longitudinal Support

PB67-43001-51

Manufactured

No

100

Each

0.0000

1

Long T-Handle Assembly

B85112

B851135

12-6-25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

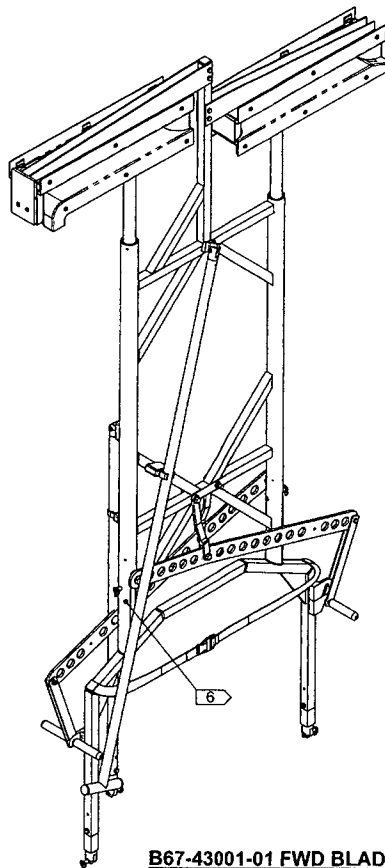
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY. -01	P/N	DESCRIPTION
	X	B67-43001-01	FWD BLADE FOLD ASSY
1	1	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-45	LONGITUDINAL SUPPORT
7	1	B67-43001-51	LONG T-HANDLE ASSY
8	2	B67-43001-261	LEVER ARM
9	4	B67-43001-265	DELIRIN BUSHING
10	2	B67-43001-299	BUSHING
11	1	D3445-041	BELT ASSEMBLY
12	2	D3447-3	SQUARE SPACER
13	2	D3447-7	CLEVIS
14	2	D3447-9	SWING ARM
15	1	D3451-041	HANDLE & LOCK-DOWN ASSY
16	1	D3451-047	HANDLE & LOCK-DOWN ASSY
17	2	D3922-1	CLIP
18	2	30345T22	LANYARD
19	2	30345T24	LANYARD
20	2	AN4-10A	BOLT
21	2	AN4-13A	BOLT
22	4	AN4-15A	BOLT
23	2	AN6-11A	BOLT
24	2	AN6-20A	BOLT
25	2	AN8-13A	BOLT
26	4	BSP43	RIVET
27	2	CR3213-4-C5	RIVET
28	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240107)
29	2	MS17984-C408	QUICK RELEASE PIN
30	2	MS17984-C418	QUICK RELEASE PIN
31	2	MS21042L3	NUT
32	8	MS21042L4	NUT
33	4	MS21042L6	NUT
34	2	MS27039-1-04	SCREW
35	2	MS27039-1-21	SCREW
36	4	MS51859-6	NYLON WASHER
37	4	MS51859-7	NYLON WASHER
38	8	MS51859-8	NYLON WASHER
39	2	NAS43DD3-68	SPACER
40	6	NAS1149DN632J	WASHER
41	4	NAS1149F0316P	WASHER
42	16	NAS1149F0432P	WASHER
43	8	NAS1149F0632P	WASHER
44	2	NAS1149F0832P	WASHER
45	A/R	242XX	LOCTITE 242 THREADLOCKER, BLUE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
POSSIBLE SUPPLIER BERTRAND BODY SHOP SUPPLIES P/N DART01K
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
- 7) WEIGHT: 49.07 lbs
- 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL $\varnothing 0.250$ DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THROUGH THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL.
- 9) INSTALL TEFLON TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING $1/8"$ DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL (2 PL PER BUSHING).
- 10) PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER MS51859 EQUIVALENT
- 11) TRIM HEAD OF MS17984-C408 QUICK PIN FLUSH TO BODY AS SHOW. TOUCH UP WITH BLACK PAINT PRIOR TO FASTENING TO FRAME.



B67-43001-01 FWD BLADE FOLD ASSY

RELEASED
2010-09-21

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 2 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011		VS	10.06.11
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-01 TITLE FWD BLADE FOLD ASSY	REV. C	
DRAWN	VS		SHEET 1 OF 2	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED			COPYRIGHT © 1995 BY DART AEROSPACE LTD	
DE APPR.			THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR SUBSANGATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.06.11			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries